

Batal Program

D205-564-011



# Work Order ID 54892

January 5, 2010 8:29:20 AM

Item ID: D2521

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw 205

21.00

Start Date: 05/01/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 20.00

Customer:

Reference:

Run Start



Approvals:

Process Plan: BA

Date: 10-1-05 Tooling:

Date:

Stop



QC:

Date: SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2521

Rev J

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2521 blank file

B 10-1-14

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio and Dwg D2521 Identify as D2521  
3-Deburr

Amf

SP 10/01/11

21

0

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Amf 10/01/18

21

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2521 PAR #: \_\_\_\_\_ Fault Category: Small Fab / W. Jet NCR: Yes No DQA: / Date: 10-01-28  
 Resolution: Accepted Disposition: USE - AS IS QA: N/C Closed: / Date: 10-01-29

NCR: <u>54892</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/01/18	130	1 part the edge are too thin of .100". R.C. cut too short on the water jet.	CP 10.01.22 per QSA 042	VERTICAL WALL ALONG ONE SIDE IS 0.275" (DWG=0.38). ACCEPTABLE. NOT HIGH STRESS AREA.	ML 10/01/22	S 10/01/22	CP 10.01.22 per QSA 042	S 10/01/22

NOTE: Date & initial all entries

# Work Order ID 54892

January 5, 2010 8:29:20 AM



Page 2

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Setup Start



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Start Date: 05/01/2010 Start Qty: 20.00



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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC8- Inspect parts - second check

0.00



P.A.

10/01/22

21

0

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

PRP 54891

0.00

Packaging

10/01/25 20  
15 JUNE

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/25  
mf  
10-1-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 5, 2010 8:29:24 AM

Page 1

Work Order ID: 54892



Parent Item: D2521



Parent Item Name: Bearpaw 205

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 20.00

Required Qty: 20.00

Comments:

Component ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
----------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MUHMWB10

Purchased

No

sf

275.3641

147.3684



B 10-1-14

UHMW 1" Black

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

243.6164

112186

122.0164

113166

121.6

Main Warehouse

ST

31.7477

111354

31.7477

113166 X 4 = 29.4736  
113591 X 16 = 117.8948

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Bearpaw		<b>Part Number:</b>	<b>D2521</b>
<b>Inspection Dwg:</b> D2521 <b>Rev:</b> J		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                         
 ☐ **Prototype**

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	.260	✓			
B	0.90	0.96	.926	✓			
C	0.27	0.330	.303	✓			
D	0.470	0.530	.500	✓			
E	21.740	21.760	21.750	✓			
F	0.72	0.780	.753	✓			
G	0.35	0.410	.382	✓			
H	11.490	11.570	11.500	✓			
I	3.41	3.47	3.428	✓			
J	11.790	11.810	11.800	✓			
K	9.47	9.53	9.500	✓			
L	7.190	7.210	7.200	✓			
M	6.910	6.970	6.940	✓			
N	44.47	44.530	44.500	✓			
O	6.590	6.650	6.620	✓			
P	0.940	0.980	.960	✓			
Q	18.97	19.03	19.000	✓			
R	0.350	0.410	.380	✓			
S	0.740	0.780	.760	✓			
T	0.240	0.280	.255	✓			
U	0.370	0.410	.395	✓			
V	0.740	0.780	.765	✓			
W	0.740	0.780	.760	✓			

<b>Measured by:</b> <i>gmk</i>	<b>Audited by:</b> <i>N.A</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10/01/18	<b>Date:</b> 10/01/22	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue      P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM <i>JA</i>	<i>gmk</i>

**DART**

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b>	
	<i>CB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. J
<i>CP</i>	<i>HT</i>	<b>D2521</b>	SHEET 1 OF 3
DATE		TITLE	SCALE
<b>06.07.28</b>		<b>205 BEARPAW</b>	NTS
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *54892*  
*BT 10-1-05*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN

DRAWN BY

**DART AEROSPACE LTD**

HAWKESBURY, ONTARIO, CANADA

CHECKED

APPROVED

DRAWING NO.

REV. J

**D2521**

SHEET 2 OF 3

DATE

TITLE

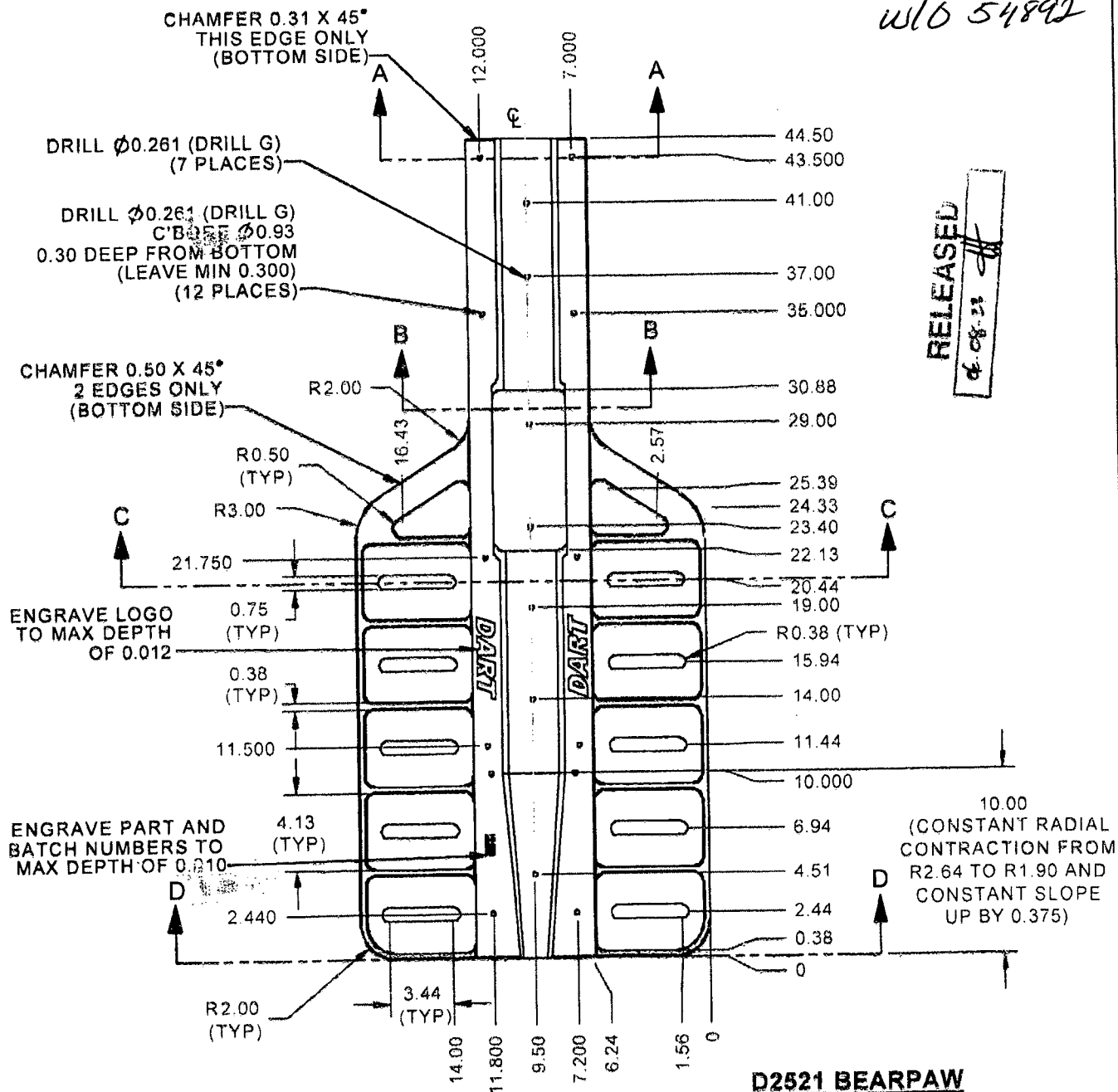
SCALE

06.07.28

**205 BEARPAW**

1:8

W/O 54892

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT C

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